

Date: Tuesday, 12/6/2005 11:12:45 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 25119	
Estimate Number : 11218	
P.O. Number : N/A	Part Number : D34173
This Issue : 12/6/2005 S.O. No. : N/A	Drawing Number : D3417 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/6/2005 Type : MACHINED PARTS	Drawing Revision : C
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/30/2005
Checked & Approved By : <u>See comment below</u>	Qty: <u>30</u> Um: <u>25</u> Each
Comment : Est Rev:A 05.10.19 New issue KJ/EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MDELRLNR12500

DELRL ROUND BAR 1.25"



Comment: Qty.: 0.0311 f(s)/Unit Total: 0.7770 f(s)

Material: Delrin Round Bar Ø1.250

(M-DELRLIN-R1.250)

Batch: M16128

Identify for D3417-3

ml 05/12/12 30

405
490
(19)

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA594 Rev: C & Dwg D3417 Rev: C

2-Deburr

ml 05/12/12 30

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 05/12/12 30

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 05/12/12 30

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 424

ml 05/12/16 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 13 Date: 05/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/6/2005 11:12:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 25119

Part Number: D34173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

505 05/12/20 (90)

12/05/12/20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

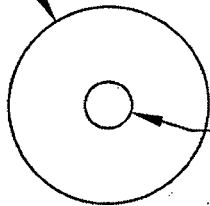
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3417	REV. C SHEET 1 OF 1
DATE 05.06.30		TITLE WASHER	SCALE 1:1
A	05.03.31	NEW ISSUE	
B	05.06.10	CHANGE TO ROUND WASHER	
C	05.06.30	REMOVE C'BORE, WIDEN	

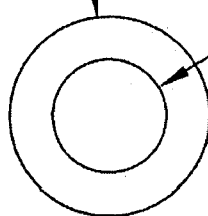
RELEASED05.11.14 *[Signature]* $\varnothing 1.125^{+0.030}_{-0.000}$  $\varnothing 0.265^{+0.005}_{-0.000}$

R1.87

0.409



0.320

 $\varnothing 1.125^{+0.030}_{-0.000}$  $\varnothing 0.640^{+0.005}_{-0.000}$

R1.87

0.346



0.260

**D3417-1 WASHER****D3417-3 WASHER****D3417-1/-3 WASHER**

- 1) MATERIAL: DELRIN (REF. DART SPEC. M-DELRIN-R1.250)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 25119

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